

Date: Thursday, 2/14/2008 2:21:03 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 37452B		
Estimate Number	: 10354		
P.O. Number	:	Part Number	: D2322
This Issue	: 2/14/2008 S.O. No. :	Drawing Number	: D2322 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 36710B	Material	:
Written By	:	Due Date	: 2/25/2008 Qty: 12 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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3



Comment: Qty.: 0.2132 sf(s)/Unit Total : 2.5578 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2322
 Batch: 106272 B 8-2-20

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2322
 Dwg Rev: C
 Prog Rev: C

B 8-2-20

(14)

2-Deburr if necessary

B 8-2-20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-2-20



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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10802-20

(14)



Comment: SECOND CHECK

counted.

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Form as per Dwg D2322

SB 02/02/27

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/03/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP SPACER

Job Number: 37452B

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Joe 27 (14)



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(14X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. L.

08/02/27

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-27

(14)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8/3/3

SD

(14X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(14)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/04

Job Completion



2008/3/04 (14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD	
Bw		CP		HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	APPROVED	MT	DRAWING NO.	REV. C
DATE		TITLE		SHEET 1 OF 1	
98.09.29		STEP SPACER		SCALE	
A		94.10.14		NEW ISSUE	
C		98.09.29		4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001	

RELEASED
18.10.98 DS

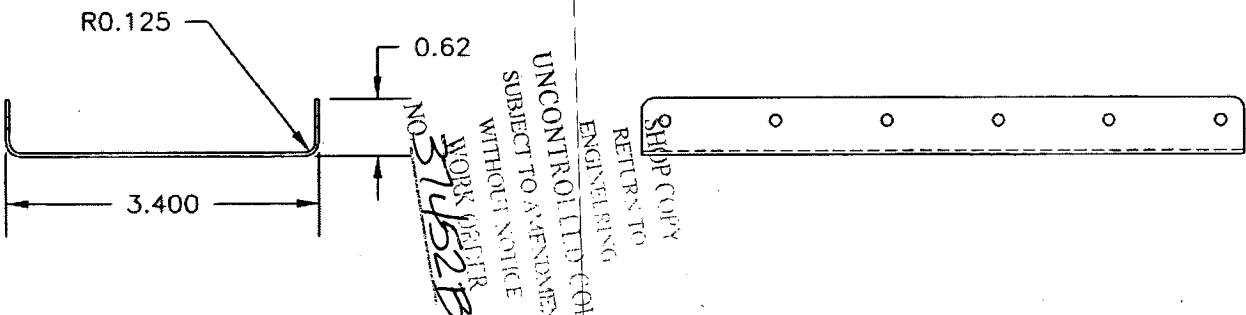
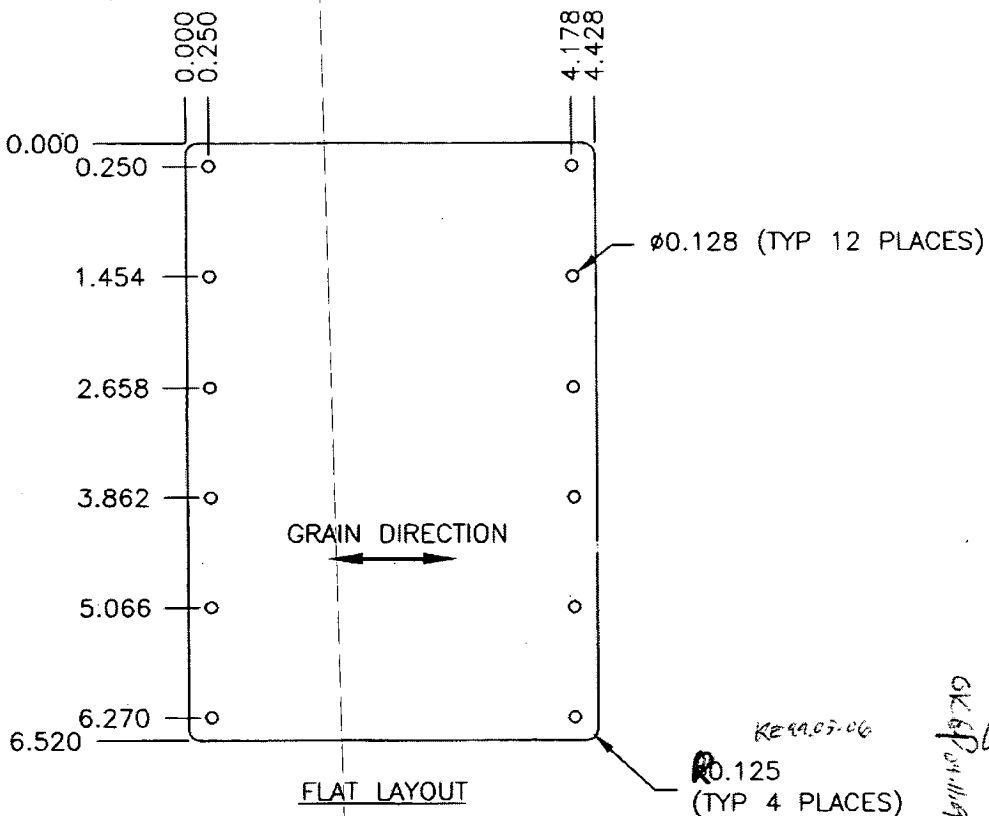
UNDER REVIEW

01.03.15 GP

DESIGN OK, BUT CHECK WITH
JTS BEFORE MANUFACTURE

GK 6P 01.11.99

KE 99.03.06



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED